

Work Order ID 56349-2

February 16, 2010 1:21:11 PM

Page 1

Item ID: D4068-041

Revision ID:

Item Name: Curved Wearplate

Start Date: 2/18/10 Start Qty: 2.00

Required Date: 2/25/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *H*

QC:

Date: 10-2-18

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4068

PA1

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4068-1 as per Dwg D4068

Dwg Rev: *PRF*

Prog Rev: *Lim*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Rev A 5/3/2012
PRELIMINARY ISSUE

10-2-22

10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56349

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Page 2

Item ID: D4068-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Curved Wearplate

Start Date: 2/18/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sidel/22

(17)

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

SB 10/02/25

(70)

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

Sidel/26

(17)

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56349

February 18, 2010 1:21:11 PM

Page 3

Item ID: D4068-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Curved Wearplate

Start Date: 2/18/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Hardecoat S.S. Batch:

0.00



Large Fab

Memo

0.00

Large Fab

160

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

perform a test
first prior to
continuing.

0.00

QC APPROVAL

POSITIVE RECALL
EFFECTIVE
RELEASED
DATE
h
710 →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56349

February 18, 2010 1:21:11 PM



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Item ID: D4068-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Curved Wearplate

Start Date: 2/18/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

10:10
3200F
10:40

5x4 m-f 13/05/29

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 φ B-5-29 (B)

200

Identify as per dwg & Stock Location: ST500

0.00



Packaging

Memo

0.00

Packaging

5x 11.10.13-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56349

February 18, 2010 1:21:11 PM



Page 5

Item ID: D4068-041

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Setup Start



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Stop



Item Name: Curved Wearplate

Start Date: 2/18/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/25/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

13/5/30

CO-021B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 18, 2010 1:21:14 PM

Page 1

Work Order ID: 56349

Parent Item: D4068-041

Parent Item Name: Curved Wearplate

Start Date: 2/18/10

Required Date: 2/25/10

Comments: IPP Rev:A new issue DD 10.02.17 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S14GA

Purchased

No

100

sf

161.5881

0.7878

3.



304SS sheet .080

1810-2-22

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

161.5881

110993Q

1.5881

113295

160

113295

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

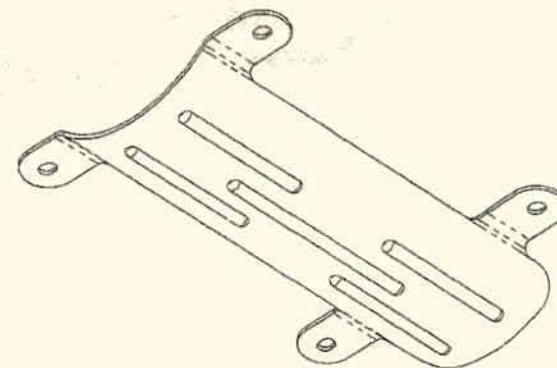
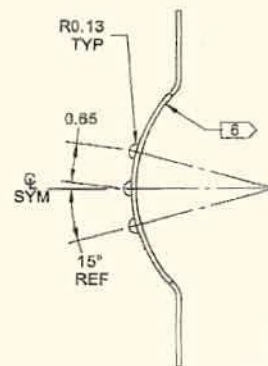
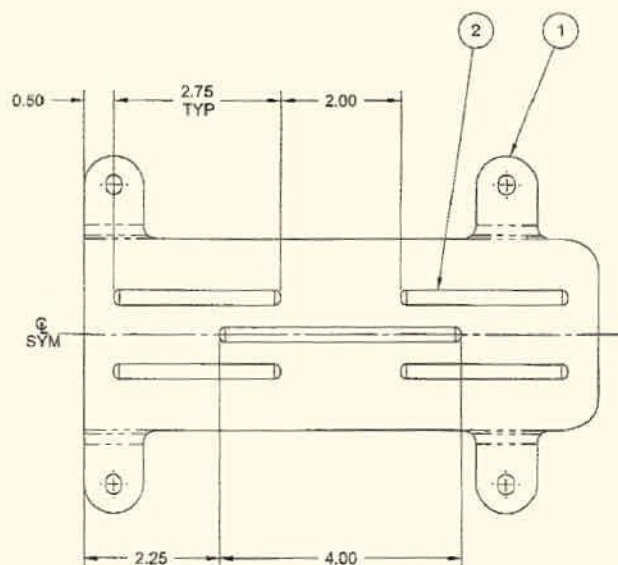
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4068-041	412 CURVED WEARPLATE
1	1	D4068-1	PLATE
2	A/R	2059B	HARDCOAT



WLB
50349

D4068-041 412 CURVED WEARPLATE

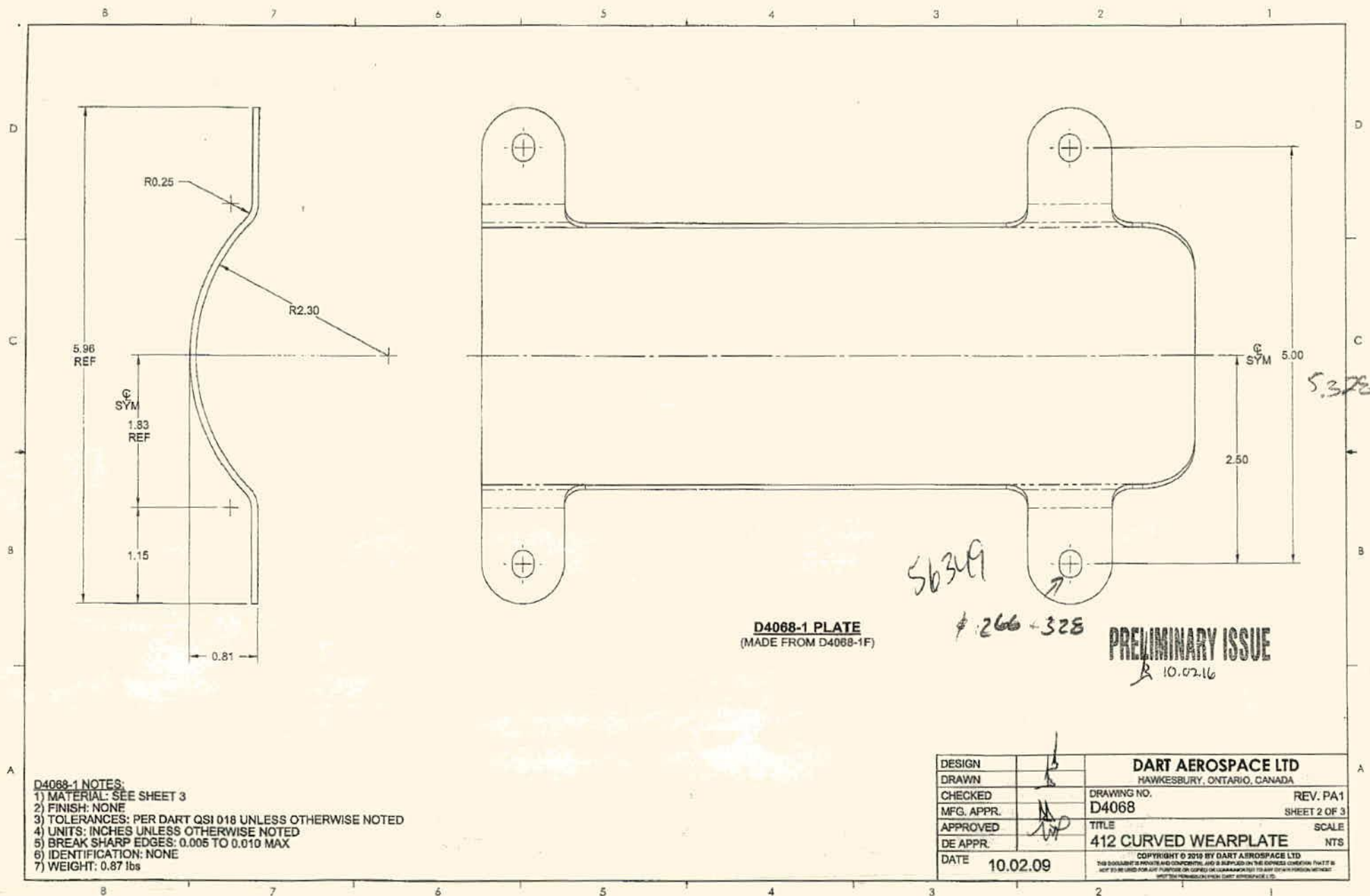
PRELIMINARY ISSUE

10-02-16

D4068-041 NOTES:

- 1) MATERIAL: SEE SHEET 3
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4068-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELDING: PER QSI 004

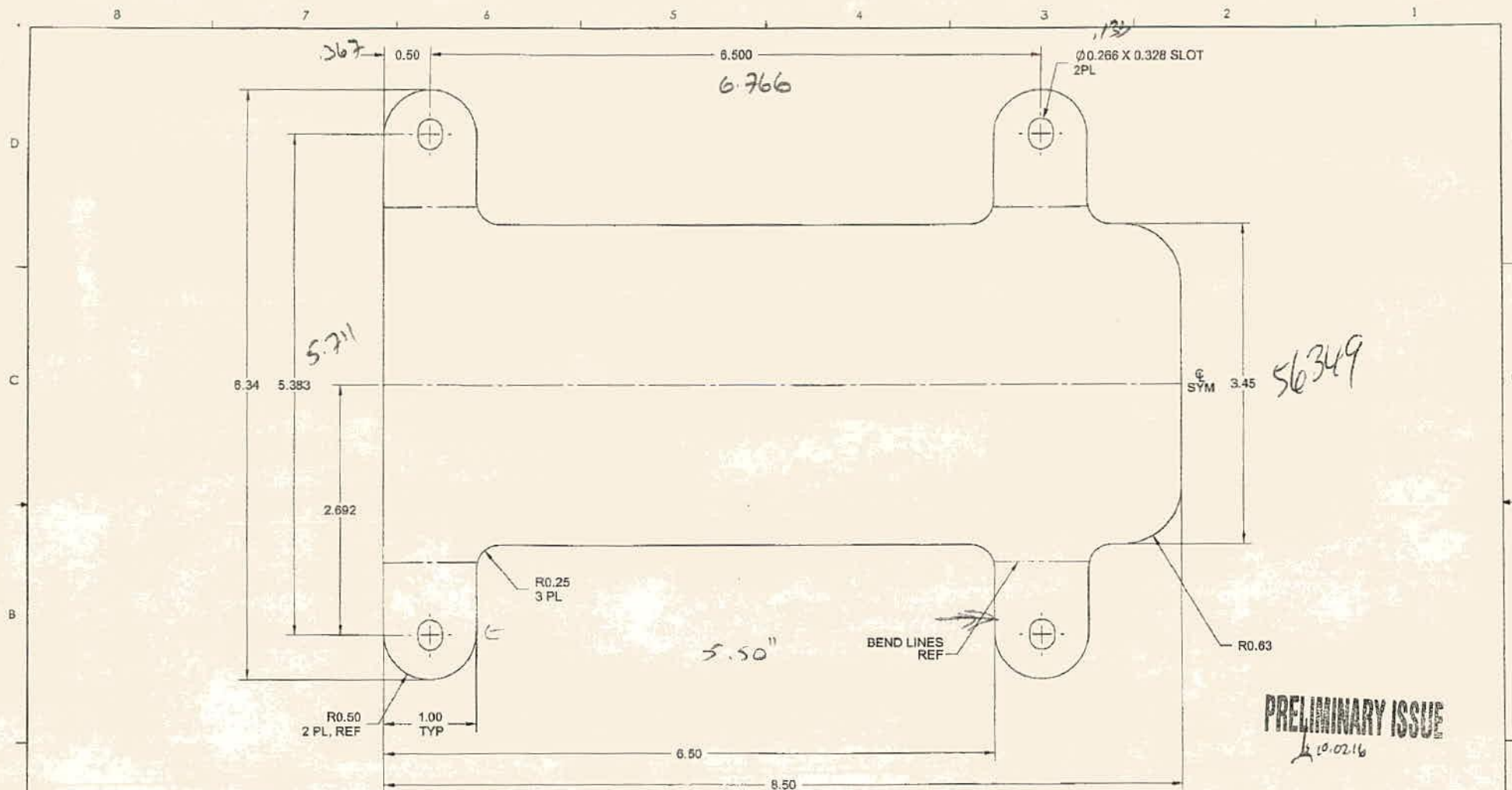
PA1	NEW ISSUE		MB	10.02.09
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. PA1	
MFG. APPR.		D4068	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		412 CURVED WEARPLATE	NTS	
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- D4068-1 NOTES:**
- 1) MATERIAL: SEE SHEET 3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.87 lbs

D4068-1 PLATE
(MADE FROM D4068-1F)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4068	REV. PA1
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		412 CURVED WEARPLATE	NTS
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D4068-1F PLATE FLAT PATTERN

D4068-1F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK) PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4068	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		412 CURVED WEARPLATE	NTS
DATE	10.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

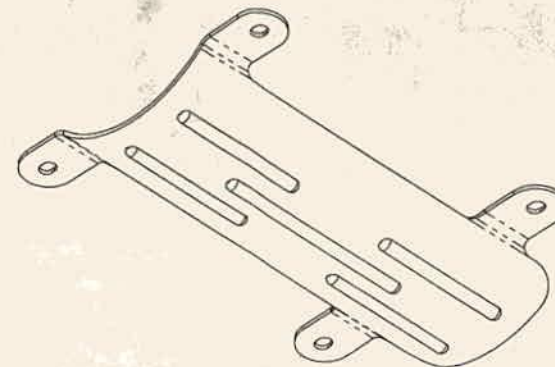
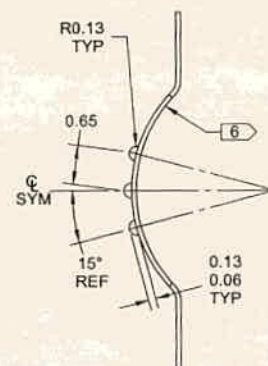
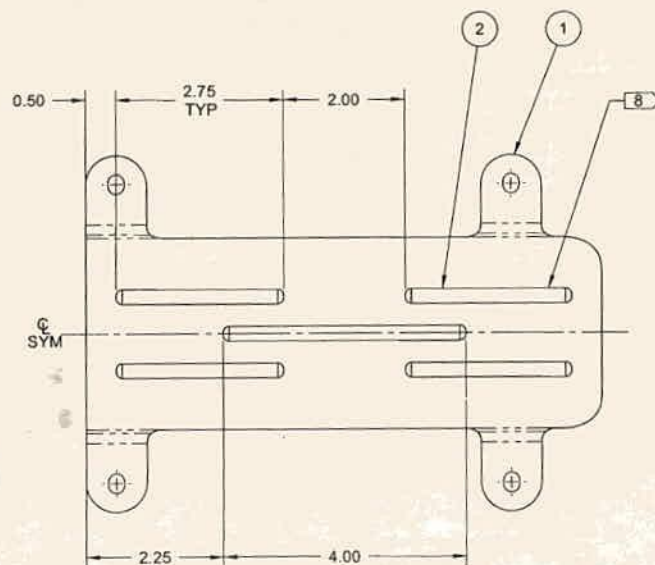
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
10/03/30	160,						

Part No: _____ Part #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NCR Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
10/03/30	160.	Check fit. "Do Not Fit." RL SKI SECTION HAS NOW A LIP ALL AROUND CREATING INTERFERENCE WITH WING PATE. PLEASE DESIGN CHANGE.	10.03.30	SPLIT W/O GRIND TWO PARTS TO FIT. HOLD 5 PARTS ON W/O SPLIT.	OK 10/03/30		10.03.30	

NOTE: Date of initial entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D4068-041	412 CURVED WEARPLATE
1	1	D4068-1	PLATE
2	A/R	2059B	HARDCOAT



D4068-041 412 CURVED WEARPLATE

RELEASED
2010-04-07
MP

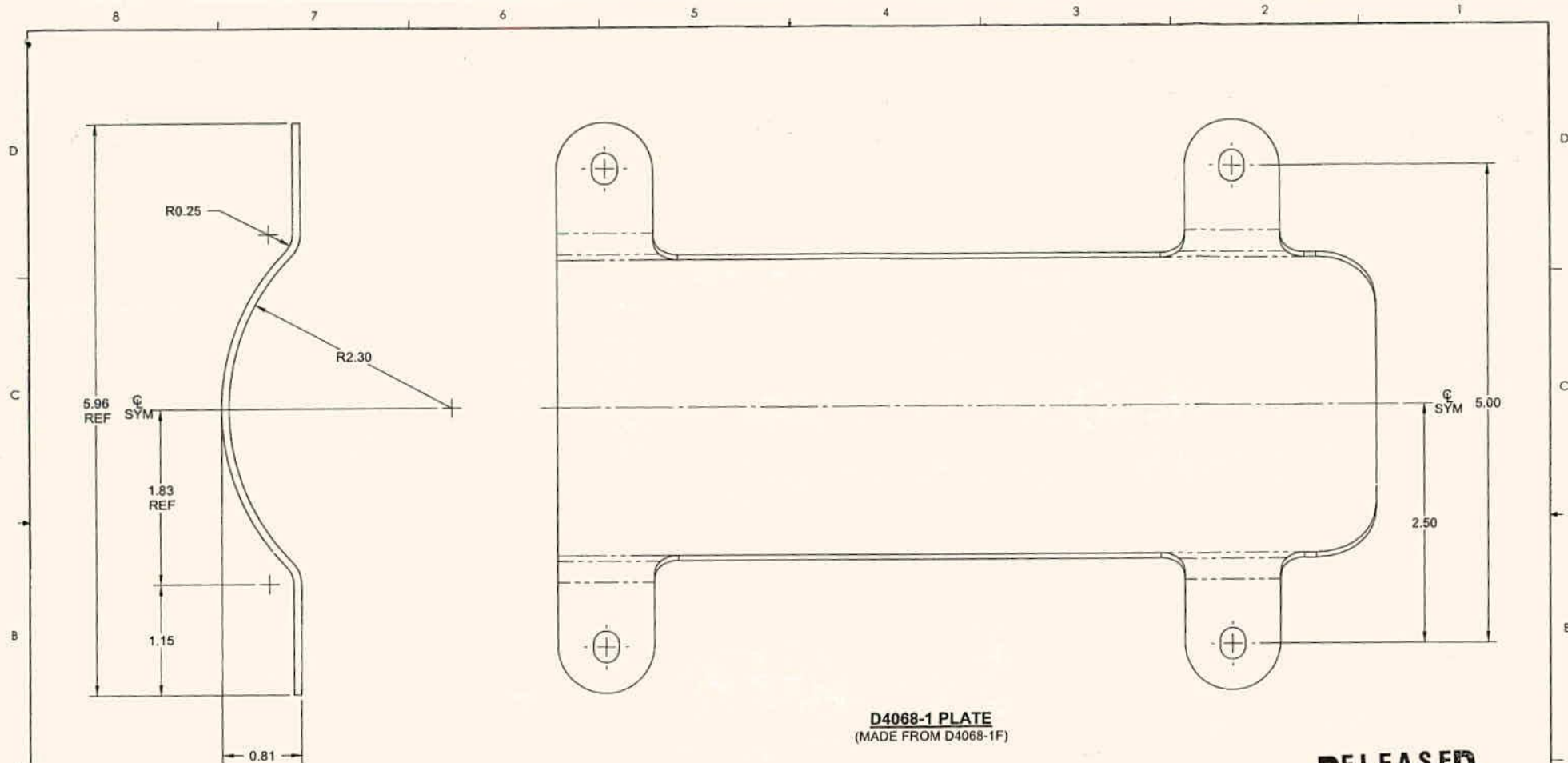
D4068-041 NOTES:

- 1) MATERIAL: SFF SHEET 3
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4068-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.87 lbs
- 8) WELDING: PER QSI 004

REV.	NEW ISSUE	DESCRIPTION	MB	10.03.31
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.31			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D4068	SHEET 1 OF 3
TITLE	412 CURVED WEARPLATE	SCALE
		NTS

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D4068-1 PLATE
(MADE FROM D4068-1F)

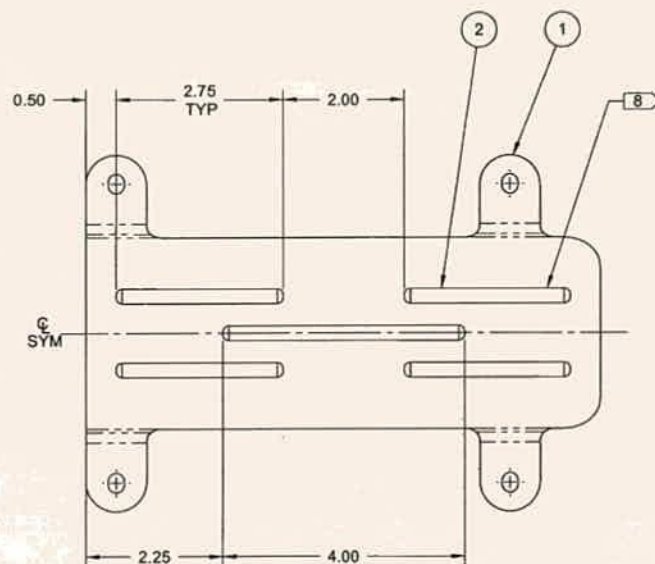
RELEASED
2010-04-07
JMS

D4068-1 NOTES:

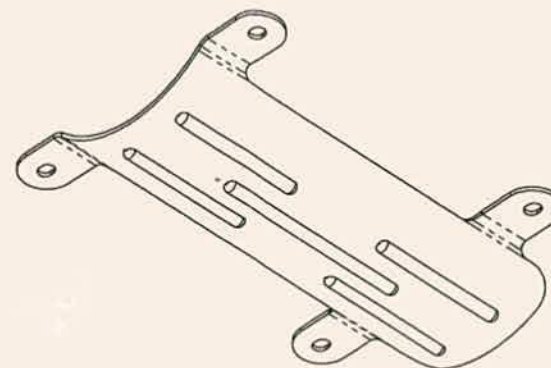
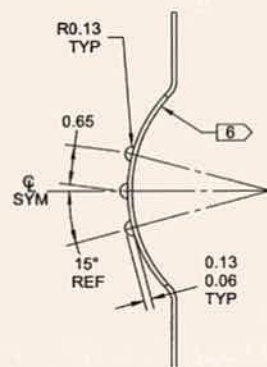
- 1) MATERIAL: SEE SHEET 3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs

DESIGN			DART AEROSPACE LTD	
DRAWN			HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4068	SHEET 2 OF 3
APPROVED			TITLE	SCALE
DE APPR.			412 CURVED WEARPLATE	NTS
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1	X	D4068-041	412 CURVED WEARPLATE
1	1	D4068-1	PLATE
2	A/R	2059B	HARDCOAT



D4068-041 412 CURVED WEARPLATE



RELEASED
2010-04-07
MP

D4068-041 NOTES:

- 1) MATERIAL: SEE SHEET 3
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REV.			BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4068	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		412 CURVED WEARPLATE	NTS	
DATE	10.03.31	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		